

Work Order ID 132677

Thursday, May 07, 2015 3:10:49 PM

132677

Page 1

Item ID: D4148-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Crosstube Lug Assembly
 Start Date: 5/7/2015 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: MAY 11 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	E								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>ST 539</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

3x 15/06/136 9-89

3 DAS 38 9-89 JUN 12 2015

3 DAS 27 9-89 JUN 15 2015

11/01/15 11:00 AM

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Page 2

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Revision ID:
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject ~ Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLJ JUN 15 2015

MLJ JUN 15 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Picklist Print

Thursday, May 07, 2015 3:10:52 PM

Page 1

Work Order ID: 132677

132677

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
 IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C
 10.10.29 as per revC DD verf:EC IPP REV:D 11.03.02
 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	791.0000	4	6			
MS21043-3									**			15/05/26	DAS 36 9-89
Nut													

Location	Loc Qty	Loc Code
FG	80	
103691	80	
FP001	65	
m130673	65	
GA	325	
m130673	15	
m131677	310	
ST304	321	
m131340	321	

MS21043-4

Purchased

No

100

Each

623.0000

1

9

MS21043-4

Nut

15/05/26
 DAS
 36
 9-89

Location	Loc Qty	Loc Code
FG	40	
104603	40	
GA	330	
m128798	330	
ST304	253	
m128818	34	
m131697	219	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

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Work Order ID: 132677

132677

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

D2690-6 Manufactured No

100 Each 11.0000 1 3

D2690-6

Lanyard

**

15/05/26 DAS 36 9-89

Location

Loc Qty

Loc Code

ST009

11

131962

11

B132747 (3x)

D3910-1 Manufactured No

100 Each 22.0000 1 3

D3910-1

Crosstube Lug

**

15/05/26 DAS 36 9-89

Location

Loc Qty

Loc Code

ST524

22

128844

22

3

D4091-1 Manufactured No

100 Each 1.0000 1 3

D4091-1

Mounting Lug

**

15/06/11 DAS 36 9-89

Location

Loc Qty

Loc Code

ST522

1

128425

1

B132509 (3x)

D4148-1 Manufactured No

100 Each 6.0000 2 6

D4148-1

Crosstube Lug Plate, Fwd

**

15/05/26 DAS 36 9-89

Location

Loc Qty

Loc Code

ST103a

6

129694

6

B132420 (6x)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Work Order ID: 132677

Parent Item: D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

132677

D4148-041

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

D4148-3 Manufactured No

100 Each 5.0000 1 3

D4148-3

Stud Receiver, Lower

**

15/05/26
DAS 36 9-89

Location

Loc Qty

Loc Code

ST103a

5

128248

1

131983

4

D4148-5 Manufactured No

100 Each 10.0000 1 3

D4148-5

Eyebolt Stud

**

3132772
15/05/26
DAS 36 9-89

Location

Loc Qty

Loc Code

ST094

10

130603

10

AN3C12A Purchased No

100 Each 216.0000 2 6

AN3C12A

Bolt

**

15/05/26
DAS 36 9-89

Location

Loc Qty

Loc Code

GA

137

M128727

137

ST349

79

M128727

79

AN4C13A Purchased No

100 Each 18.0000 3 9

AN4C13A

BOLT

**

15/05/26
DAS 36 9-89

Location

Loc Qty

Loc Code

ST344

18

131677

10

m128818

8

M132344
94

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Parent Item Name: Fwd Crosstube Lug Assembly

132677

D4148-041

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

MS17984-C413

Purchased

No

100

Each

147.0000

1

3

MS17984-C413

Quick Release Pin

**

15/05/26

DAS
36
9-89

Location

Loc Qty

Loc Code

ST312A

147

131677

147

3

MS20615-4M18

Purchased

No

100

Each

499.0000

8

24

MS20615-4M18

Rivet

**

15/05/26

DAS
36
9-89

Location

Loc Qty

Loc Code

CCK003

370

m123810

370

GA

22

m130358

22

ST307

107

125162

107

24

NAS1149C0332R

Purchased

No

100

Each

2,869.000

4

12

NAS1149C0332R

WASHER

**

15/05/26

DAS
36
9-89

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

642

m131618

642

ST260a

87

m131697

87

12

DQA: _____ Date: _____

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Picklist Print

Thursday, May 07, 2015 3:10:52 PM

Page 5

Work Order ID: 132677

132677

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0432R

Purchased

No

100

Each

2,823.000

6

18

NAS1149C0432R

WASHER

15/05/26
DA: 36
9-89

Location

Loc Qty

Loc Code

GA

2158

m125807

476

m131467

1682

ST271

665

m131452

665

18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Misidentified ☐	Past Due ☐																																																																												
☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong																																																																										
☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions																																																																										
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance																																																																										
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect																																																																										
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing																																																																										
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved																																																																										
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing																																																																										
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish																																																																										
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread																																																																										
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence																																																																										
OTHER :																																																																													